5/29

DART AEROSPACE LTD			Work Order:	23635
Description: STA.84 bracket			Part Number:	D2803-1
Dwg: D2803 rev. A			Qty:	~~10~~ 20

Step	Location	Procedure	By	Date	Qty	
1	EXPEDITING	Issue W/O	JA	05.06.21	~~10~~	20
2	METAL	Cut blanks per template DT8533 Material: 6061-T6 bar 10.00" x 0.50" Batch: ~~M4427~~ M10958	BC	05.06.26	10	20
3	HAAS	Machine as per folio FA102 M9878	BG	05.06.27	10	20
4	QC	Inspect Level 2	BG	05.06.27	10	20
5	QC	Inspect Level 8	Er	05/06/27	10	20
6	METAL	Tumble & Deburr	BC	05.06.27	10	20
7	QC	Inspect Level 5	En	05/06/27	10	20
8	FINISHING	Chemical conversion coat per QSI 005	FF	05.06.29	10	20 FF
9	STORES	Identify and stock	ML	05/08/05	~~20~~	RTO
10	EXPEDITING	Close W/O Cost / part: 52.63 Suc 05/08/05 (20) 53.27	JA	05/08/05	20	

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	

RELEASED

EC 00.11.06

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05/08/03	9	Use 10 for B23625 and put the 10 others in Stores.	ml	05/08/05	10		

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: ⟍⟍ Date: 05/08/05

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD				Work Order:	23635	
Description: Bracket				Part Number:	D2803-1	
Inspection Dwg: D2803 Rev: B					Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article**   [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.625	+/-0.010				Dimension is not on Dwg.	
Ø0.757	+0.005/-0.000	.761	✓			
Ø0.191	+0.005/-0.000	.191	✓			
Ø0.507	+0.000/-0.001	.5062	✓			
13.558	+/-0.010	13.558	✓			
Ø0.507	+0.000/-0.001	.5062	✓			
12.411	+/-0.010	12.411	✓			
2.654	+0.000/-0.001	2.6535	✓			
0.437	+0.000/-0.001	.4365	✓			
1.420	+/-0.001	1.420	✓			
6.933	+/-0.010	6.933	✓			
0.250	+/-0.010	.254	✓			
0.875	+0.000/-0.001	.8741	✓			
0.250	+0.000/-0.005	.248	✓			
0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.130	✓			
0.125	+/-0.010	.130	✓			
0.125	+/-0.010	.176	✓			
0.500	+/-0.010	.492	✓			
0.562	+/-0.010	.554	✓			
0.188	+/-0.010	.188	✓			

Measured by:	BG	Audited by:	E	Prototype Approval:	N/A
Date:	05.06.26	Date:	05/06/26	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	05.04.25	New Issue		KJ/JLM	CM

RELEASED 05.05.03

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CP	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2803	SHEET 1 OF 2
DATE		TITLE	SCALE
04.11.22		STA 84 BRACKET	1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & −043/−044	

DART

RELEASED
05.03.11

Ø0.757 +0.005 −0.000
(2 PLACES)

R0.625

0.875 +0.000 −0.001

0.250

0.250 +0.000 −0.005

0.125

R0.062 (TYP)

R0.125 (TYP)

SECTION A−A
SCALE 2:3
(ROTATED)

0.125 — 0.500

0.125

R0.125 (TYP)

SECTION B−B
SCALE 2:3
(ROTATED)

0.188 — 0.562

0.125

R0.125 (TYP)

SECTION C−C
SCALE 2:3
(ROTATED)

B

B

B

12.411

0.608 +0.000 −0.001

R0.300 (TYP)

Ø0.191 +0.005 −0.000 (2 PLACES)

A

A

A

C

1.420±0.001

R1.000

Ø0.191 +0.005 −0.000

Ø0.507 +0.000 −0.001 C'BORE
0.250 DEEP

R0.30 (TYP)

R0.625

C

C

2.654 +0.000 −0.001

0.437 +0.000 −0.001

Ø0.507 +0.000 −0.001

6.933

C

13.558

WORK ORDER
NO. 23635
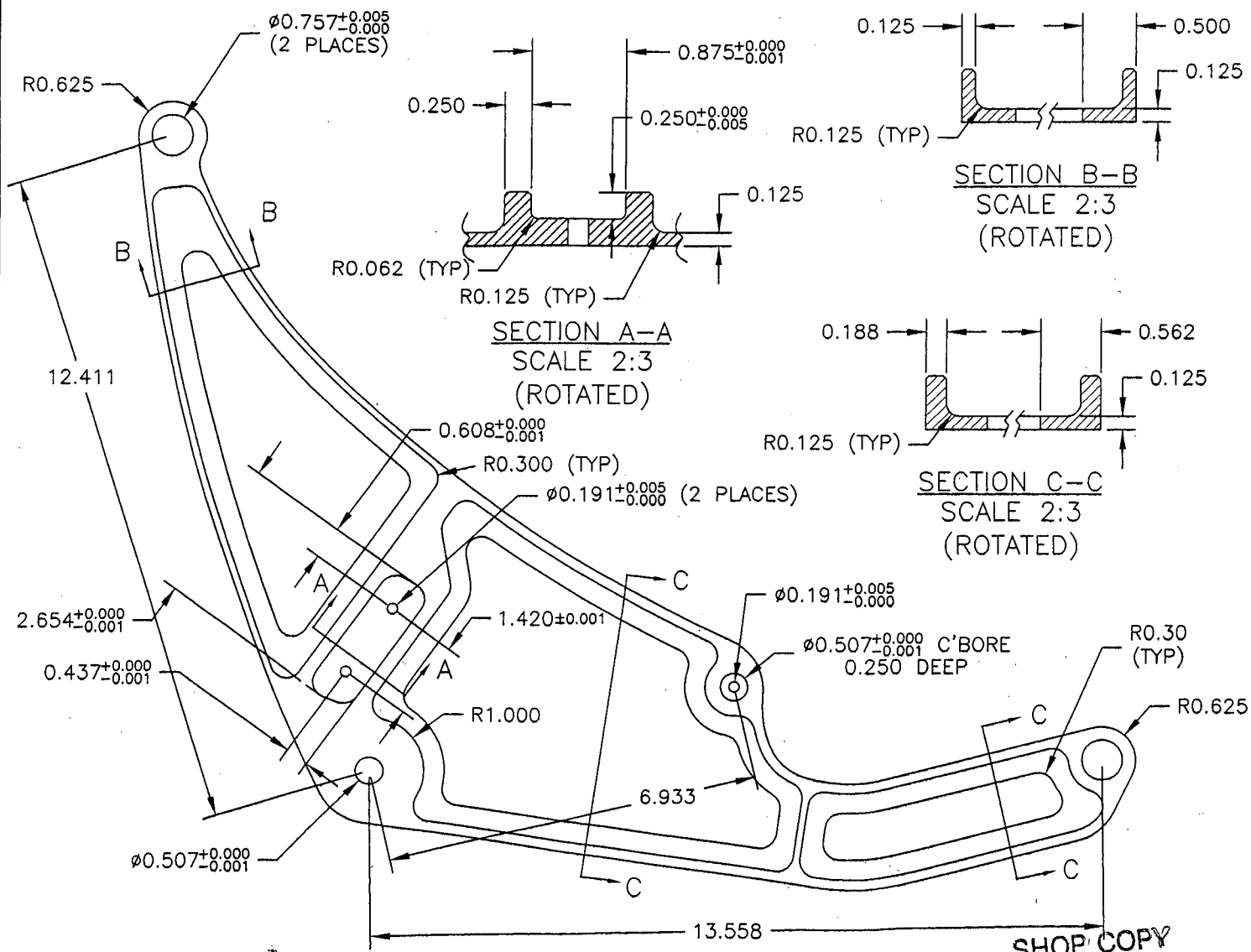
D2803−1 BRACKET (SHOWN). D2803−2 BRACKET (OPPOSITE)

1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
2) MATERIAL: 6061−T6 (QQ−A−200/8) OR (QQ−A−250/11) 0.500 THICK
3) DEBURR TO LEAVE R0.030 − 0.063 ON ALL EDGES
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Dart Aerospace Ltd.   Jun 20, 2005
Hawkesbury   03:23 pm

Work Order No	:	0023635
Project Name	:	D2803-1
Project For	:	WK529
Work Order Type	:	Main
Main WO Number	:	
House Part Number	:	D2803-1
Description	:	STA 84 Bracket
Manufactured	:	Yes
Amount Req'd	:	10
Amount Done	:	0
Start Date	:	06-20-05
Est Finish Date	:	07-23-05
Act Finish Date	:	
Drawings Reqd	:	No
Ok for Approval	:	
Approval Rec'd	:	

Department Code:		
Burden Flags	:	NNNNNNN
WO Status	:	Open
Invoice State	:	Not Invoiced
Invoice Date	:	
Invoice Number	:	
Invoice Amount	:	0.00
Order Entry No	:	
OE Value	:	0.00
Est Mark Up	:	0.000%
Actual Mark Up	:	0.000%

$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00